

Date: Monday, 07/04/2008 11:47:02 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: FWD X-TUBE		
<b>Job Number</b>	: 38424			<b>Part Number</b>	: D2889		
<b>Estimate Number</b>	: 10006			<b>Drawing Number</b>	: D2889 REV B		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 07/04/2008	<b>S.O. No.</b>	:	<b>Drawing Revision</b>	: B		
<b>Prsht Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: / /	<b>Type</b>	: LANDING GEAR	<b>Due Date</b>	: 10/05/2008	<b>Qty:</b>	1
<b>Previous Run</b>	: 38423			<b>Um:</b>	Each		
<b>Written By</b>	:						
<b>Checked &amp; Approved By</b>	: JTO 08.04.06						
<b>Comment</b>	: Est Rev:A New Issue 05-10-25 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6005180	Crosstube material
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Crosstube material Pick: Qty Part number Description Batch 1 D2889 Fwd Crosstube <u>34687</u>		
2.0	BENDING	BENDING MACHINE - SKIDTUBES
<b>Comment:</b> LANDING GEAR RESOURCE 1 1-Bend D2889 as per Dwg D2889 and Folio FT001		
3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
<b>Comment:</b> LANDING GEAR RESOURCE 1 1-Deburr and Polish		
4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
<b>Comment:</b> DIMENSIONAL CHECK OF X-TUBES		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<b>Comment:</b> HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube		

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 38424

Part Number: D2889

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Used  
~~Used~~ on w/o 37946  
08/04/08

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Do 8/04/15

Job Completion

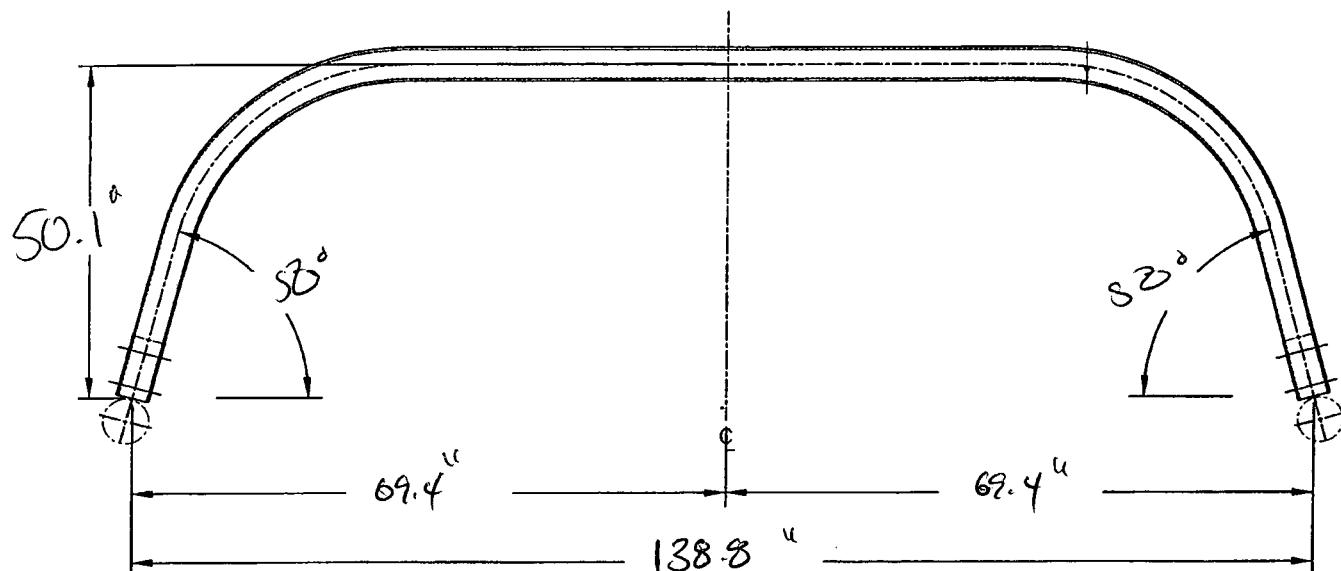


MF 08-04-10

W

DART AEROSPACE LTD	Work Order:	38424
Description: Crosstube Fwd	Part Number:	D2889
Inspection Dwg: D2889	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments

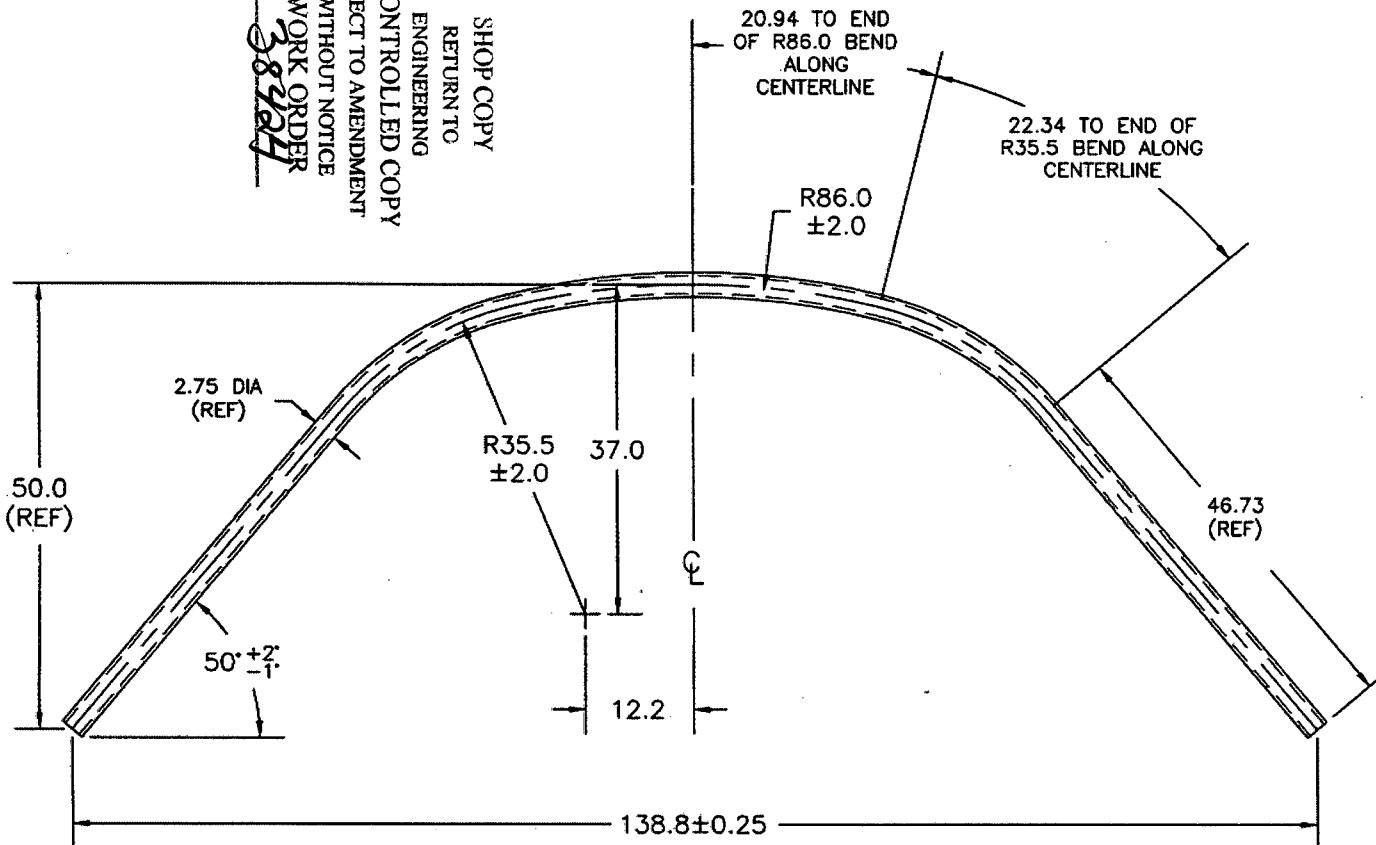
QC15 Inspection	58/06/09
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	JM

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WITHOUT NOTICE  
WORK ORDER  
NO. 38424



NOTES

- 1) MATERIAL: MANUFACTURE FROM D6005-180 ( $\varnothing 2.75$  OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

RELEASED  
02.10.28



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. B
02.10.18	FWD CROSSTUBE	D2889
A	99.05.21	SHEET 1 OF 1
B	02.10.18	1:20
	ADD TANGENT LENGTHS; CHANGE NOTES	SCALE